

Date: Thursday, 28/08/2008 1:16:39 PM
 User: Melanie Fauteux

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: SUPPORT ANGLE		
Job Number	41656	3	Part Number	: D36981		
Estimate Number	13281		Drawing Number	: D3698 REV B		
P.O. Number			Project Number	: N/A		
This Issue	28/08/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	NC		Material	:		
First Issue	11	Type : SMALL /MED FAB	Due Date	04/09/2008	Qty:	8 Um: Each
Previous Run	41022					
Written By						
Checked & Approved By		MF 08-08-28				
Comment	: Est Rev:A 08-04-25 new issue DD verified by:EC					
	Est Rev:B 08-07-14 revB as per dwg DD verified by:ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S032	6061-T6 Sheet 0.032"	
		4	
		Comment: Qty.: 0.4700 sf(s)/Unit Total : 3.7598 sf(s) 6061T6 aluminium sheet .032" thick (M6061T6S032) Batch: 18375	
		BB 8-8-29	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3698 Dwg Rev: B Prog Rev: B ****grain direction along 1.378" **** 2- Deburr if necessary BB 8-8-29	
			11
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		BB 8-8-29	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	SO 08/08/08 (AC)
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Bend 105 deg. angle as per Dwg D3698	BB 08/09/08 (AC)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ANGLE

Job Number: 41656

Part Number: D36981

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form curve as per dwg D3698 and verify using template DT9001

FF 08/09/09

(1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/09 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1



Chemical Conversion Coat as per QSI 005 4.1

FF 08/09/09

(1)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING



Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1



Identify and Stock

Location: 9A

WED 28/08/08 08:00:00

FF 08/09/09

(1)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

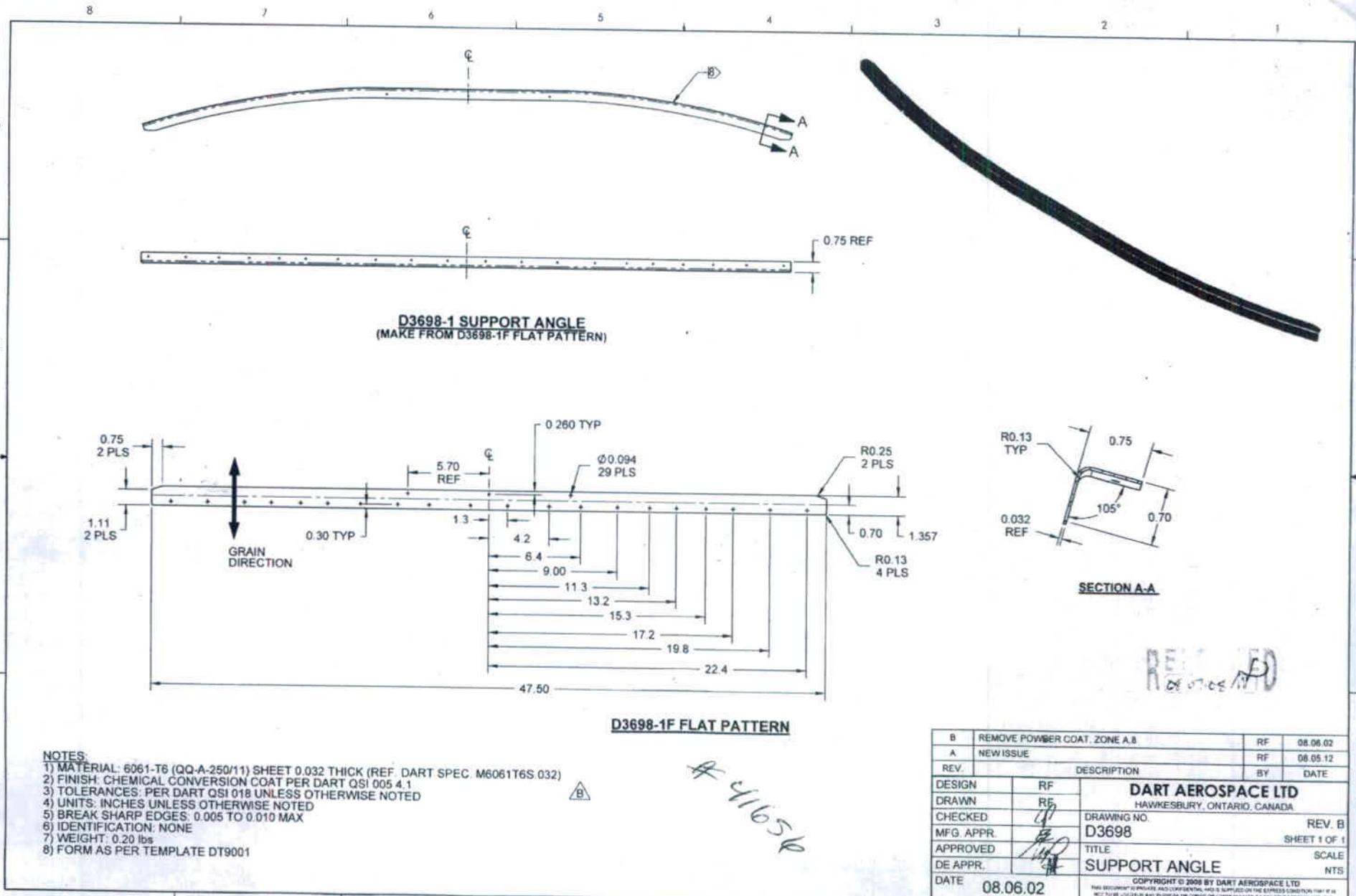
08/09/09

Job Completion



MF 08-09-09





B	REMOVE POWDER COAT, ZONE A.8	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3698	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SUPPORT ANGLE	NTS
DATE	08.06.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

AT AEROSPACE LTD

Work Order:

41656

Description: SUPPORT ANGLE

Part Number: D 3698-1

Inspection Dwg: 13698-1 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:

12

Date: _____

9-8-21

Audited by:

1

Date: 05/05/29

Prototype Approval:

17

Date: _____

7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

20

